

Date: Wednesday, 6/28/2006 4:17:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BO 105 SKID TUBE 'I' BEAM
Job Number	: 27742	Part Number	: D2976
Estimate Number	: 11075	Drawing Number	: D2976 REV A1
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 6/28/2006	Drawing Revision	: A1
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 7/15/2006
Previous Run	: N/A	Qty:	6
Written By	<i>See Comment (below)</i>		
Checked & Approved By	<i>DT 06 06 29</i>		
Comment	: Est. C 02.10.30 Re-format KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2963084	105 I Beam Extrusion
		Comment: Qty.: 4.5938 Each(s)/Unit Total : 27.5625 Each(s) Extrusion, I Beam' thin Pick: Qty Part Number Description Batch 1 D2963-084 Extrusion <i>B14459 DP 6-7-16</i> <i>06-07-15</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 Cut D2963-084 extrusion to length: (82.00") Use Jig DT8546 to drill pilot holes Open holes to finish size per dwg D2976 Deburr <i>DP 6-7-10 ①</i> <i>06-07-13</i>
3.0	HAND FINISHING 1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>85 06-07-14</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP <i>DP 6-7-17 ①</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>L6 DP 6-7-17 ⑥</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DS Date: 06/07/24

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKID TUBE 'I' BEAM

Job Number: 27742

Part Number: D2976

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

106.07.18

Job Completion



u-06.07.18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

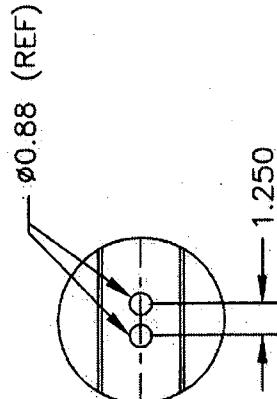
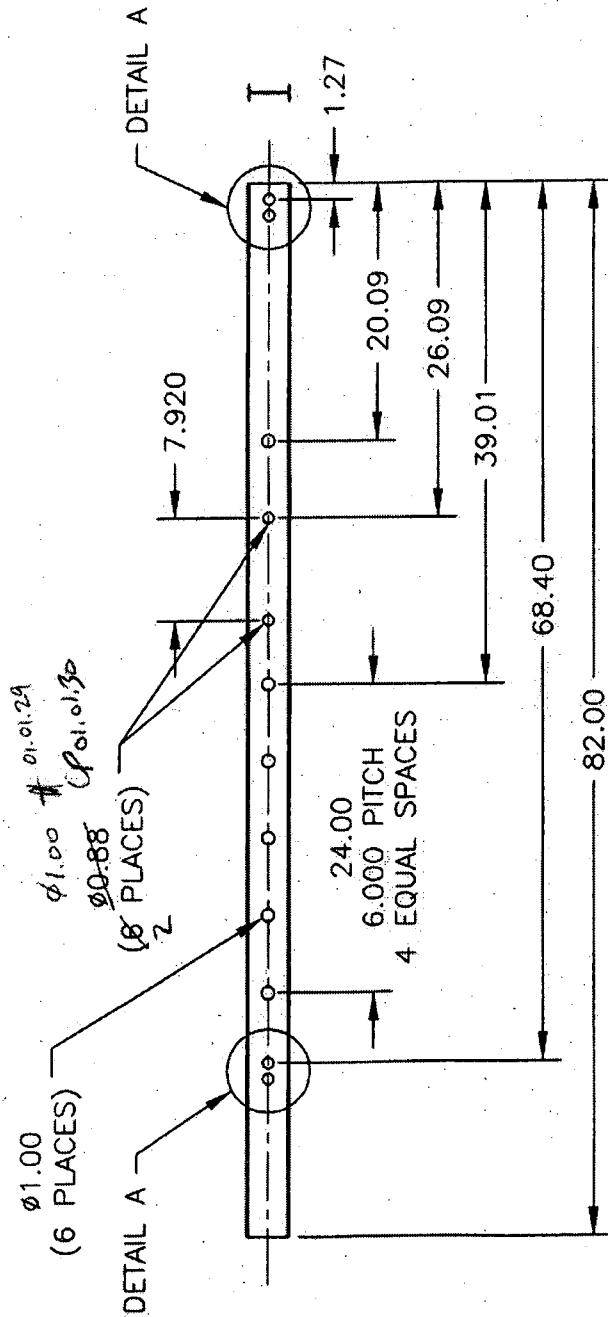
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DARTDRAFT COPY
DRAFTS

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2976
DATE 00.03.14		REV. A SHEET 1 OF 1
		SCALE 1:14
A	00.03.14	WEB
A1	01.01.29	OPEN GROUND HANDLING HOLES TO $\phi 1.00$

RELEASED
00.05.11 *#*

SHOP COPY

RETURN TO

ENGINEERING

'INCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27742

MAKE FROM D2963-084 EXTRUSION
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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